

Work Order ID 52896

October 19, 2009 10:38:44 AM



Page 1

Item ID: D3173-041

Revision ID: B

Item Name: Beam Assembly

Start Date: 10/19/09 Start Qty: 6.00

Required Date: 10/27/09 Req'd Qty: 6.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 09-16-19 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3173	Rev B

100



BAND SAW

Bandsaw

Memo

0.00

0.00

G.A
09/10/25

2 Ø

20356

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

0.00

G.A
09/10/25

2 Ø

120



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

0.00

G.A
09/10/25

2 Ø

Quality Control

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Item ID: D3173-041

Accept



Setup

Stop



Revision ID: B

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Start Date: 10/19/09 Start Qty: 6.00



Cust Item ID:

Required Date: 10/27/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
Code

Qty

Accept
Reject
Qty

2

Reject
Number

10

Insp.
Stamp

140



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Drill Ø0.316" holes as per Dwg D3173 112-C'sink holes as per Dwg
D3173 113-deburr

EF 09/10/27 ②

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

z) S or 10/29

② f

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Start Date: 10/19/09 Start Qty: 6.00

Accept



Setup Start



Required Date: 10/27/09 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



HandFinish

Hand Finishing

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

MD 09/11/02 X2

170



QC

Quality Control

~~QES~~-Inspect part completeness to step on WO
FINISH
 QC3
 S Memo

0.00

BL 09-11-2

(2)

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M 112148

0.00

BL 09-11-2

(2)

Memo
 Ensure Nut Plate thread is covered.
 1:15 (OVEN TEMPERATURE:
 TIME: 1:45) START TIME:
 320° (FINISH)

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Required Date: 10/27/09 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

→ S o l u z

0.00

f

200



Small Fab

Small Fab

0.00

E/309/11/24 Q

Small Fab

Small Fab

Memo

0.00

Assemble per Dwg D3173. Install Mounting Lug as per Dwg D3173. D3173-041 is included in K10017 BOM.

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ S o l u z

0.00

(x2) f

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Item ID: D3173-041

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Beam Assembly

Start Date: 10/19/09 Start Qty: 6.00



Cust Item ID:

Required Date: 10/27/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**

220



Packaging

Identify as per dwg & Stock Location: S16**Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

0.00

0.00

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Picklist Print

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5

Work Order ID: 52896



Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly

Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5		Purchased		No		100	Each	1,118.000	12.0000		EBS09/11/03	

Nut

Warehouse

Location

Main Warehouse

ST	1118
110382	10
111127	4
111636	104
112314	1000

D3178-041RevA



Manufactured

No

170 Each 18.0000 12.0000

Nut Plate

Warehouse

Location

Main Warehouse

ST	18
24895	10
25298	8

EBS09/11/03

EBS09/11/03

4

Picklist Print

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Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly

Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6TR4.0X2.0W1 25		Purchased	No			170	f	15.9600	29.6053			

6061-T6 Rect Tube 4.0 x 2.0 x .125w



Warehouse

Location

Main Warehouse

MAT	15.96
109025	0.31
109088	10.16
14394	4.66
19265	0.83

Loc Qty

Loc Code

AN3-5A

Purchased

No

200

Each

2,259.000 48.0000



Bolt

9.8 1 H.A 09/10/26

E/S 09/11/03 24

Warehouse

Location

Main Warehouse

ST	2259
100188	188
105057	2071

Loc Qty

Loc Code

Picklist Print

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Parent Item Name: Beam Assembly

Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-23A		Purchased	No			200	Each	25.0000	12.0000		EJ 09/11/09	

Bolt



Warehouse

Location

Main Warehouse

ST

Loc QtyLoc Code

25

25

AN960JD10



Purchased

No

19278

200

Each

1,920.000 48.0000



4

Washer

Warehouse

Location

Main Warehouse

ST

Loc QtyLoc Code

1920

105442

95

109059

2

109840

23

110985

202

111279

5

111668

64

112314

1000

112369

529

816

Picklist Print

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Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			200	Each	1,688.000	24.0000		E809/11/09	

Washer



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	Loc Qty	Loc Code
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	68	
112314	500	
112794	274	
112828	500	8

Picklist Print

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Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3175-041RevA		Manufactured	No			200	Each	6.0000	12.0000		E/S 09/11/03 24 b6345822	

Mounting Lug

Warehouse

Location

Main Warehouse

ST	6
25025	1
41678	5

MS20601-AD4W4

Purchased

No

200 Each 47.0000 48.0000



Rivet

Warehouse

Location

Main Warehouse

ST	47
19278	47

16

D3065-5DART AEROSPACE LTD	Work Order:	52896
Description: Beam	Part Number:	D3173-1
Inspection Dwg: D3173	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.A	Audited by:	✓	Prototype Approval:	N/A
Date:	09/10/25	Date:	09/10/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3173-041	KJ/RF	FF



QC
ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3173	SHEET 1 OF 3
DATE		TITLE	SCALE
03.01.07		BEAM ASSEMBLY	NTS
A	02.12.03	NEW ISSUE	
B	03.01.07	REMOVE PIP PINS	

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3173-041	BEAM ASSEMBLY
1	D3173-1	BEAM
2	D3175-041	MOUNTING LUG
2	D3178-041	NUT PLATE
8	AN960JD10	WASHER
4	AN960JD516	WASHER
2	MS21042L5	NUT
8	MS20601AD4W4	RIVET
8	AN3-5A	BOLT
2	AN5-23A	BOLT

NOTES

D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 52296

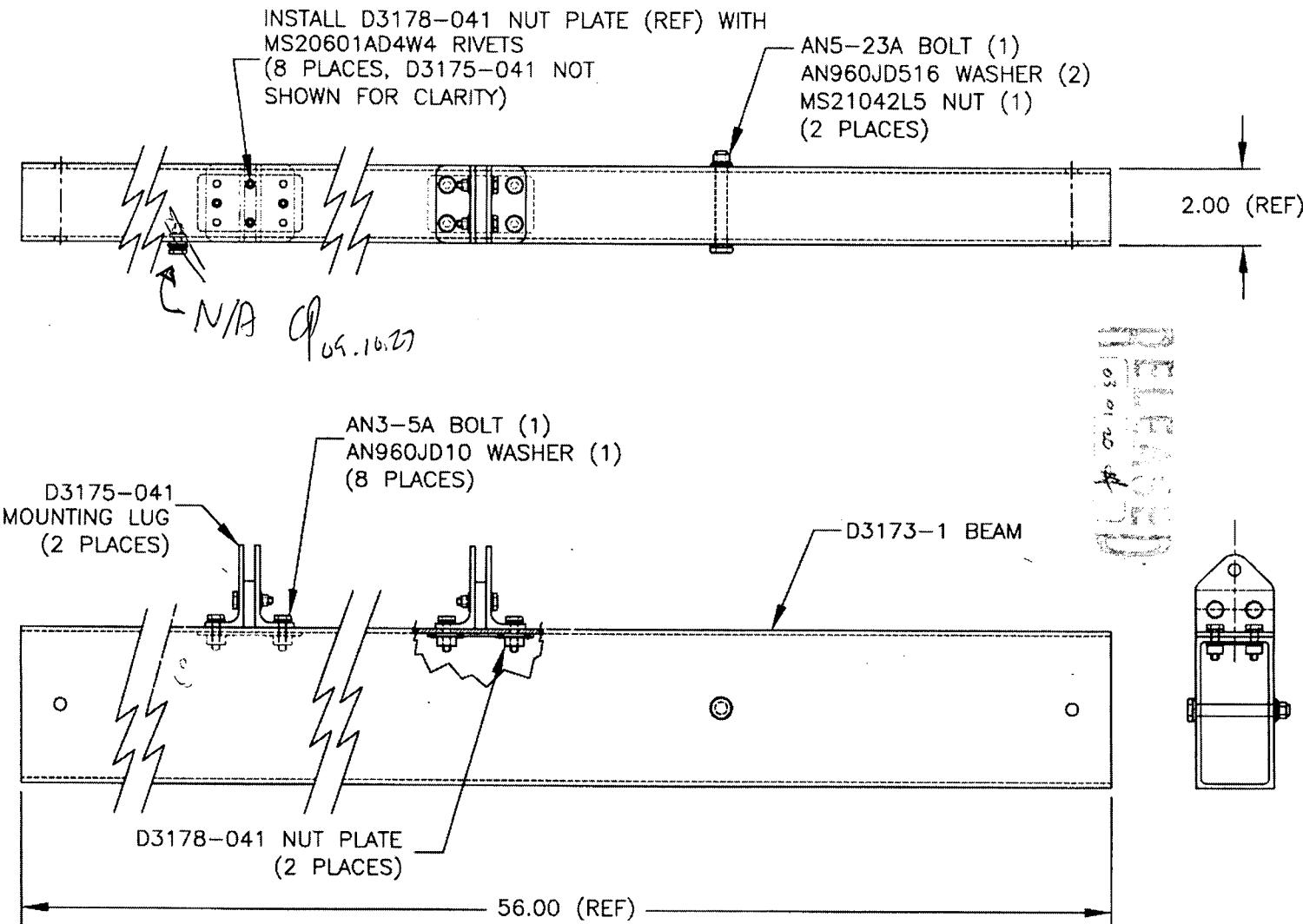
BR 09-10-11

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DATE		SHEET 2 OF 3 SCALE 1:4

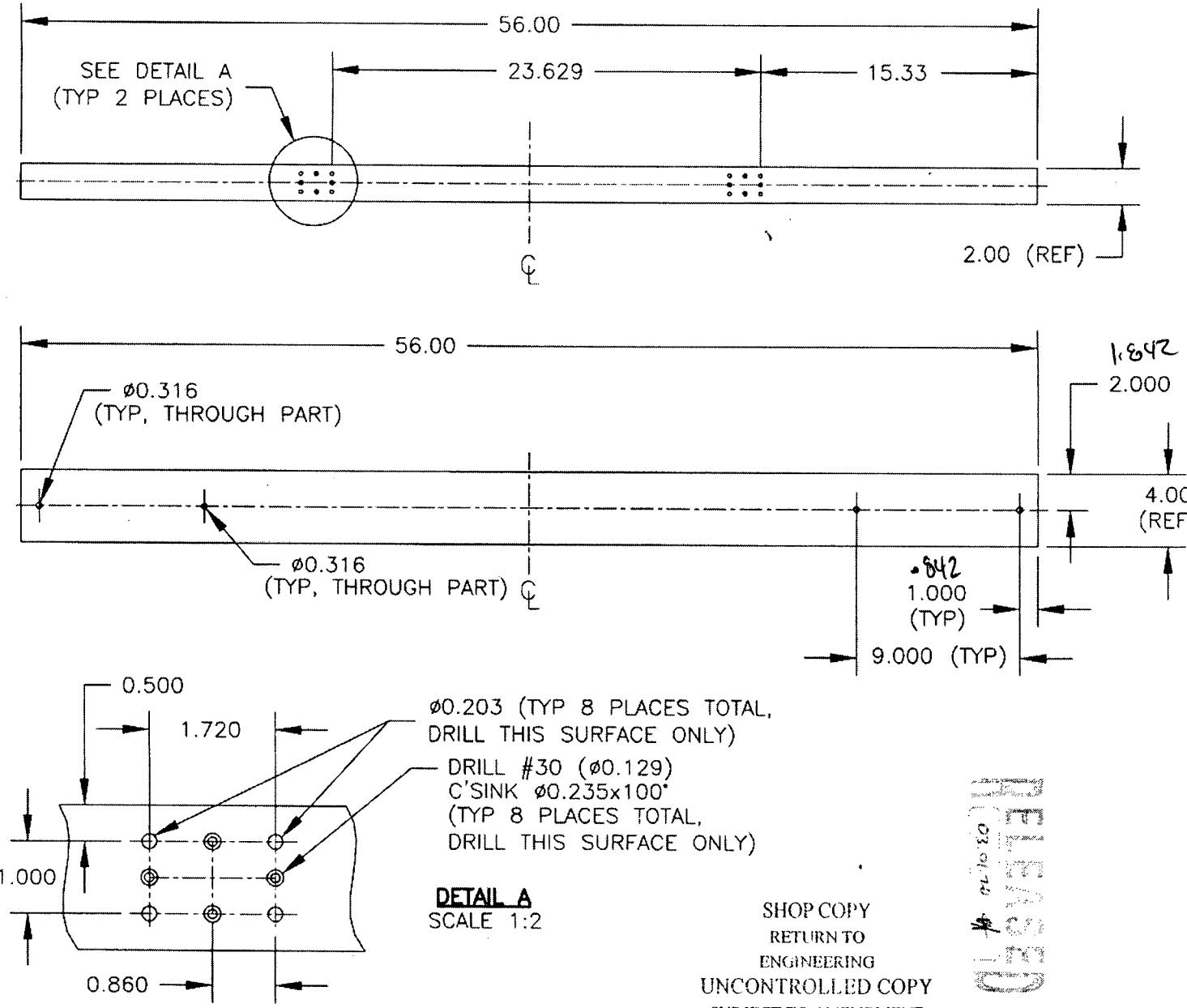
**D3173-041 BEAM ASSEMBLY**

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DATE	APPROVED	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3173
DATE	APPROVED	SHEET 3 OF 3
03.01.07	APPROVED	SCALE 1:8
		TITLE BEAM ASSEMBLY